

GREEN

Dart Aerospace Ltd.

Date: Thursday, 4/26/2007 3:34:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number : 32079	
Estimate Number : 10534	
P.O. Number : <u>N/A</u>	Part Number : D2574
This Issue : 4/26/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2574 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 31722	Material : <u>N/A</u>
Written By : _____	Due Date : 5/30/2007 Qty: 10 Um: Each
Checked & Approved By : <u>07.04.26</u>	
Comment : Est Rev: As Per RevE 06-01-27 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 7075-T7351 8.25X5.0X2.5
 Make from D6101-005 billet for D2574
 Ensure that grain is along 5.00" length
 Batch No: _____

B25350 (x10)

En 07/5/30

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 832079 Double check by J-F

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

En/Amk 07/6/03

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 Machine keyway as per dwg D2573 & D2574

En /Amk 07/6/03

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

En/Amk 07/6/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/10/05

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/06/04 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FL 07/05/04 (10)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat - OLIVE DRAB GREEN

(Ref: 4.3.5.1) as per QSI 005 4.3

M/04476.

FL 07/06/04 (10)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 07/06/05 (10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FL 07/06/05 (10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FL 07/06/05

Job Completion



U 07/06/05

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DART AEROSPACE LTD	Work Order:	32079
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.747	1.749	1.749	1.749		
C	3.495	3.505		3.499	3.499	3.499	3.500		
D	1.745	1.755		1.747	1.749	1.749	1.749		
E	7.990	8.010		8.000	8.000	8.001	8.001		
F	0.490	0.510		0.498	0.500	0.501	0.504		
G	0.257	0.262	DT8683	0.260	0.260	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.503	0.502	0.502		
J	1.174	1.184		1.175	1.178	1.177	1.178		
K	0.558	0.578		0.564	0.570	0.570	0.570		
L	1.174	1.184		1.175	1.178	1.177	1.178		
M	1.365	1.375		1.366	1.369	1.368	1.369		
N	2.495	2.505		2.496	2.499	2.499	2.500		
O	4.119	4.129		4.124	4.121	4.121	4.122		
P	0.115	0.135		0.126	0.126	0.127	0.127		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.251	0.251		
S	0.115	0.135		0.127	0.129	0.127	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.230	3.230	3.236	3.230		
V	0.230	0.250		0.240	0.240	0.246	0.241		
W	0.115	0.135		0.126	0.130	0.132	0.134		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.364	0.358	0.364	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.616	0.619	0.627	0.628		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.248	0.253	0.253		
AE	1.500	1.520		1.510	1.512	1.512	1.510		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.265	0.269	0.262		
AH	0.240	0.260		0.250	0.247	0.248	0.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	En/ gml
Date:	07/06/01

Audited by:	JA
Date:	07.06.02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

WORK ORDER CHANGES

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR:-Yes No DQA: _____ Date: _____

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

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B	1.745	1.755		1.746	1.748	1.747	1.748		
C	3.495	3.505		3.501	3.500	3.501	3.499		
D	1.745	1.755		1.746	1.748	1.747	1.748		
E	7.990	8.010		8.002	8.002	8.004	8.004		
F	0.490	0.510		0.501	0.499	0.498	0.500		
G	0.257	0.262	DT8683	0.259	0.259	0.260	0.260		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.504	0.503	0.502	0.501		
J	1.174	1.184		1.178	1.178	1.178	1.178		
K	0.558	0.578		0.571	0.572	0.567	0.569		
L	1.174	1.184		1.178	1.179	1.178	1.178		
M	1.365	1.375		1.368	1.369	1.369	1.369		
N	2.495	2.505		2.500	2.500	2.497	2.499		
O	4.119	4.129		4.121	4.122	4.121	4.122		
P	0.115	0.135		0.126	0.126	0.126	0.126		
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S	0.115	0.135		0.128	0.127	0.126	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.236	3.236	3.230	3.230		
V	0.230	0.250		0.241	0.239	0.236	0.240		
W	0.115	0.135		0.125	0.126	0.127	0.126		
X	0.307	0.312		0.311	0.311	0.312	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.360	0.360	0.360	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.625	0.623	0.623	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.253	0.246	0.245	0.245		
AE	1.500	1.520		1.511	1.511	1.512	1.512		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.265	0.265	0.260	0.260		
AH	0.240	0.260		0.249	0.246	0.244	0.245		
AI	2.000	2.020		2.000	2.001	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	<i>and / sp</i>
Date:	<i>07/06/02</i>

Audited by:	<i>J.F.</i>
Date:	<i>07/06/04</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
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C	3.495	3.505		3.500	3.499				
D	1.745	1.755		1.740	1.748				
E	7.990	8.010		8.003	8.002				
F	0.490	0.510		0.502	0.498				
G	0.257	0.262	DT8683	0.260	0.260				
H	0.375	0.380	DT8684	0.377	0.379				
I	0.490	0.510		0.499	0.497				
J	1.174	1.184		1.177	1.174				
K	0.558	0.578		0.565	0.566				
L	1.174	1.184		1.177	1.174				
M	1.365	1.375		1.367	1.365				
N	2.495	2.505		2.496	2.497				
O	4.119	4.129		4.121	4.120				
P	0.115	0.135		0.127	0.126				
Q	0.115	0.135		0.135	0.135				
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S	0.115	0.135		0.122	0.125				
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V	0.230	0.250		0.237	0.238				
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AA	0.470	0.530		0.500	0.500				
AB	0.615	0.635		0.627	0.624				
AC	0.053	0.073		0.063	0.063				
AD	0.240	0.260		0.244	0.243				
AE	1.500	1.520		1.513	1.514				
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AI	2.000	2.020		2.000	2.000				
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Measured by: <i>en</i>
Date: 07/06/03

Audited by: J.F.
Date: 07/06/04

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
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Dart Aerospace Ltd

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED

05.12.06

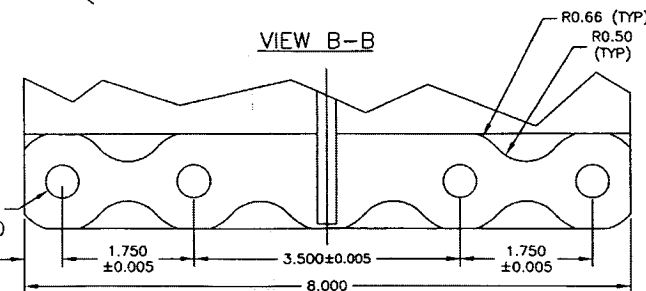
NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

E

VIEW B-B

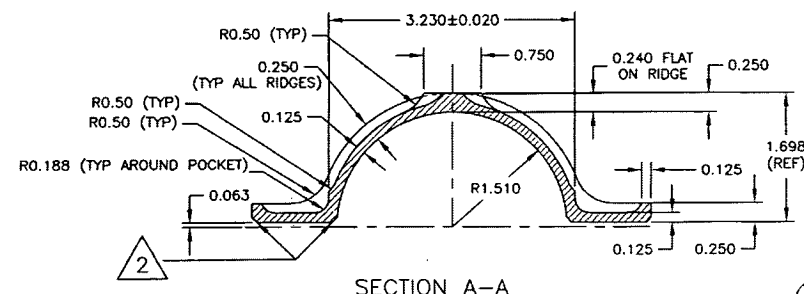
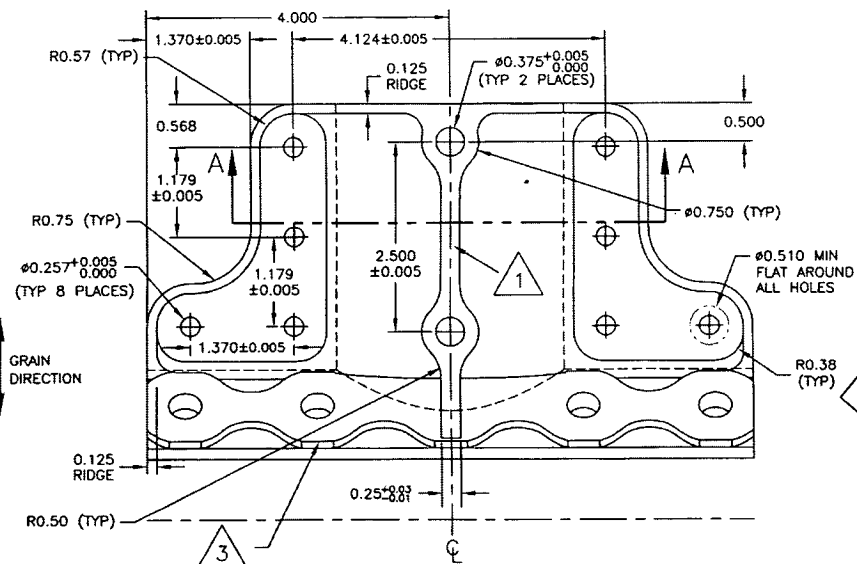


E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DS	DRAWN BY	PH	DART	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO.	D2574
DATE	05.07.13	TITLE	INNER AFT SADDLE		
				REV. E	SHEET 1 OF 1
				SCALE	2:3

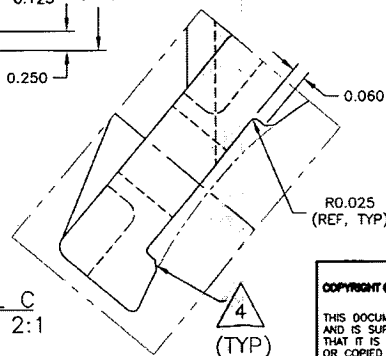
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THAT IT IS NOT TO BE USED FOR ANY PURPOSE
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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.



SECTION A-A

DETAIL C
SCALE 2:1



NO. 33079
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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